

Work Order ID 162086

Thursday, May 25, 2017 9:28:14 AM

162086

RUSH SUP

Page 1

Item ID: D3536-13 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Gasket Forward

Start Date: 5/25/2017 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 5/26/2017 Req'd Qty: 6.00 *6* Customer:

Reference:

DAS
21
9-89

Approvals: Process Plan: _____ Date: MAY 25 2017 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3536	Rev A

100 0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3536 Dwg Rev: 1 Prog Rev: A 2-
 Deburr if necessary

0.23

DAS
20
9-89
Q/KC 17/05/25

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.06

DAS
20
9-89
Q/KC 17/05/25

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.12

Q/KC
 DAS
38
9-89
MAY 25 2017

Work Order ID 162086

Thursday, May 25, 2017 9:28:14 AM

162086

Page 2

Item ID: D3536-13

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gasket Forward

Start Date: 5/25/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/26/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: St-1B	0.00				6			
130									
Packaging	Memo	0.06							
Packaging	LOCATION: PP001								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.60							
Quality Control									

MAY 25 2017

DAS

6

9-89

DAS

21

9-89

DAS

21

9-89

MAY 25 2017

DAS
21
9-89

MAY 25 2017

Picklist Print

Thursday, May 25, 2017 9:28:17 AM

Page 1

Work Order ID: 162086

162086

Parent Item: D3536-13

D3536-13

Parent Item Name: Gasket Forward

Start Date: 5/25/2017

Required Date: 5/26/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MNEO60S.063

Purchased

No

100

sf

154.9269

0.8269

5.512667

MNEO60S 063

**

NEOPRENE SHEET 0.063

No.110750002 NEOPRENE DURO 60+/-5 "A" 1/16" IMPORT GR PT

DAS
20
9.94
17/05/25

Location

Loc Qty

Loc Code

GA

8.2149

M131990

8.2149

MAT

31.8

M135551

31.8

MAT052

114.912

M136565

9.762

M137313

105.15

??
??

6

DART AEROSPACE LTD		Work Order: 162086
Description: Gasket		Part Number: D3536-13
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32,90	1			
29.40	+/-0.030	29,40	1			
27.40	+/-0.030	27,40	1			
23.90	+/-0.030	23,90	1			
18.98	+/-0.030	18,98	1			
14.07	+/-0.030	14,07	1			
9.15	+/-0.030	9,15	1			
5.65	+/-0.030	5,65	1			
3.90	+/-0.030	3,90	1			
8.00	+/-0.030	8,00	1			
14.00	+/-0.030	14,00	1			
20.00	+/-0.030	20,00	1			
1.89	+/-0.030	1,89	1			
0.30	+/-0.030	0,30	1			
0.30	+/-0.030	0,30	1			
Ø0.19	+0.005/-0.001	0,19	1			

Measured by: SC	Audited by: 38	Prototype Approval:	N/A
Date: 17/05/25	Date: MAY 25 2017	Date:	N/A

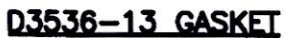
Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	EE

09.02.12-1

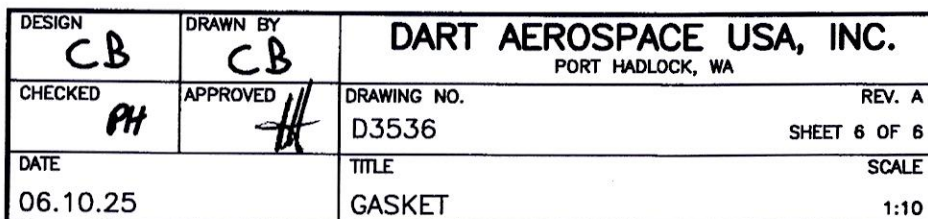
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
PH		D3536	SHEET 1 OF 6
DATE	TITLE		SCALE
06.10.25	GASKET		1:10
A	06.10.25	NEW ISSUE	



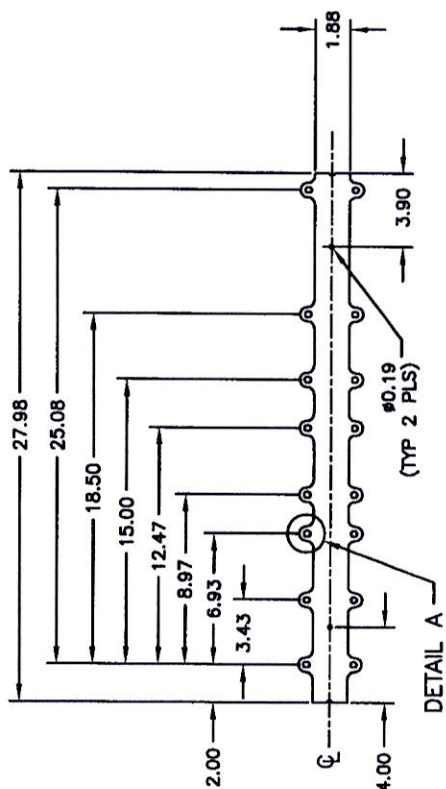
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162086



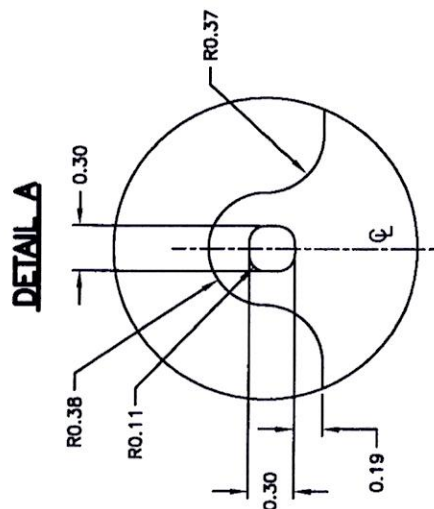
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



07.02.12



D3536-41 GASKET

**Notes**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S-083)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

Copyright © 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.